

<b>GEARTECH</b>	CHECKLIST			No. CK8600	SHEET 1 OF 4
				Rev. A	
Gearbox Assembly				BY RLE	DATE 9/09/99
				CKD JRM	DATE 9/09/99
FACILITIES					
Question	Y	N	R	Comments	
Is assembly area separate and clean?					
Is floor painted and clean?					
Is overhead structure clean?					
Is lighting adequate?					
Is area free of drafts?					
Is area free of tow motors?					
Are windows and doors shut?					
TECHNICIAN TRAINING and TOOLS					
Question	Y	N	R	Comments	
Is smoking prohibited?					
Are technicians properly trained?					
Are technicians properly equipped?					
Have technicians emptied their pockets?					
Are tools adequate and proper for job?					
Are tools in good condition and properly calibrated?					
Are tools put away immediately after use?					
Are unnecessary tools removed?					
Are metal hammers removed?					
Are machining and deburring done outside assembly area?					
Are deburring tools, files, sandpaper, grinders, etc. removed from assembly area?					
Are assembly benches adequate?					
Is hydraulic press adequate?					
Is proper lifting equipment available?					
Are proper lifting techniques used?					
Are proper jacks for leveling the housing used?					
COMPONENT STORAGE					
Question	Y	N	R	Comments	
Are components marked with proper serial number?					
Do components have QA certificates showing conforming product?					
Are components properly stored?					
Are components covered?					
Are bearings stored on their sides?					

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Question	Y	N	R	Comments	
Are lip seals stored separately in boxes to protect them?					
<b>COMPONENT DEBURRING</b>					
Question	Y	N	R	Comments	
Are all components deburred in an area separate from assembly?					
Are gear housings deburred in separate area?					
Do all gear teeth have adequate tip, edge, and end rounds?					
Do all shaft journals have adequate chamfers?					
Do all bearing caps have adequate puller holes?					
Do all threaded holes have adequate chamfers?					
<b>COMPONENT CLEANING</b>					
Question	Y	N	R	Comments	
Are all components cleaned in area separate from assembly?					
Are gear housings cleaned in separate area?					
Are solvent tanks adequate?					
Is cleaning fluid proper?					
Are rags lint free?					
Are all drilled holes clean?					
Are all threaded holes clean?					
<b>HOUSEKEEPING</b>					
Question	Y	N	R	Comments	
Has assembly area been vacuumed before assembly starts?					
Are gear housings vacuumed before assembly?					
Are housing splitlines clean and flat?					
Are housing recesses and bolt holes clean?					
Are gear housings covered when unattended?					
Are all components clean and rust free?					
Are all components covered when unattended?					
Are all shaft seal surfaces covered and protected from damage?					

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		Rev. A		
Gearbox Assembly		BY RLE		DATE 9/09/99
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ASSEMBLY TECHNIQUE				
Question	Y	N	R	Comments
Are shaft and gear bore diameters recorded before assembling shrink-fit gears?				
Are shaft diameters recorded before assembling bearing inner races?				
Question	Y	N	R	Comments
Are bearing inner races heated with an induction heater?				
Are bearing inner races held against shaft shoulder during cooling?				
Is pushing through rolling elements disallowed?				
Is hammering disallowed on any bearing components?				
Are separable C-R bearings assembled with adequate tools and procedures to avoid damage?				
Do bearings rotate freely after assembly with shaft?				
Are bearing endplays properly set?				
Are bearing pins properly installed?				
Are bolts properly torqued?				
Are lockwires properly applied?				
Are all seals pressed into retainers without hammers?				
Are all lip seals lubricated at assembly?				
Are all seals assembled over shafts using sleeves to protect seal lips?				
Are all shafts free to float axially with housing cover installed?				
Is housing free of $M_oS_2$ ?				
CONTACT PATTERNS				
Question	Y	N	R	Comments
Are contact patterns checked in housing per CK8700?				
Are splitlines leveled using leveling jacks?				
Are splitlines flat?				
Is marking compound clean and properly applied?				
Are covers installed before contact pattern testing?				
Are dowel pins installed?				

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Question	Y	N	R	Comments	
Are gears rolled with light torque?					
Is cover removed for inspection?					
Are patterns documented with tapes?					
Is marking compound removed?					
Is DYKEM tested for compatibility with lubricant?					
Is DYKEM properly applied?					
Are covers installed using sealant sparingly?					
PREPARATION FOR TESTING					
Question	Y	N	R	Comments	
Are all gear housing openings sealed?					
Do all gearsets have adequate backlash?					
Do lube system components conform to lube schematic?					
Are guidelines for tests being followed?					